

20-8486



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3065-5**Job Sheet 204367****Part No:** D3065-5**Job Qty:** 80 pcs**Part Name:** Step Leg**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 12/9/19**Job Tracking No:****Due Date:** 12/10/19**Created By:** Kimberley Guerin**Type:** Stock**Description:**

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
122	Purchasing	80 pcs	12/10/19	12/10/19	0.00	0.00	Purchasing - 1		DP DEC 09 2019
							Purchasing - 2		
							Purchasing - 3		
123	Packaging 2-1 - Receive - B4B	80 pcs	12/10/19	12/10/19	0.00	0.00	Packaging 2 - 1 - B4B		DP DEC 09 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S238377**Part:** D3065-5**Job No:** 204367**Serial No/Batch:** S238377**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 12/09/19

				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
124 QC 6	80 pcs	12/10/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
125 Waterjet - Flow - B4B	80 pcs	12/10/19	0.00 1.33	Waterjet - Flow - B4B	
130 Handfinish - 1-1 Chemical-B4B	80 pcs	12/10/19	0.00 1.81	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	

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					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140 QC 7	80 pcs	12/10/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
150 Packaging 3-1 - Stock - B4B	80 pcs	12/10/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	

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				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	GA 127 F
				Packaging 3 - 23 - B4B	PC GA 127 F
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	80 pcs	12/10/19	0.00 0.00	QC 21 - SA - 21	GA 127 F
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-00

Part Op 122 - ISSUE P/O: _____ MANUFACTURE D3065-5 AS PER DWG *****IMPORTANT, VERIFY GRAIN
 Descriptions: DIRECTION AS PER DWG***** C OF C IS REQUIRED
 125 - *****CHECK GRAIN DIRECTION***** DEBURR ON DEBURRING MACHINE (no set-up time required)
 130 - Chemical Conversion Coat per QSI005 4.1
 140 - QC7-Inspect Chemical Conversion Coat
 150 - Identify as per dwg & Stock Location: _____ - LOCATION : GA
 160 - QC21- Final Inspection - Work Order Release

Job BOM					
Part / Item D3065-5P	Component Name Step Leg	Quantity 80 Ea (1 ea)	Operation 122-Purchasing	Container 5238375	
Job Allocations					
Operation 122-Purchasing	Component Part D3065-5P	Required 80	Inventory 0	Allocated 0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Log	16.458inches ± 0.010	16.468 16.448		
2	Step Log	15.750inches ± 0.005	15.755 15.745		
3	Step Log	2.250inches ± 0.005	2.255 2.245		
4	Step Log	3.460inches ± 0.005	3.465 3.455		
5	Step Log	0.865inches ± 0.005	0.870 0.860		
6	Step Log	6.020inches ± 0.005	6.025 6.015		
7	Step Log	1.205inches ± 0.005	1.210 1.200		
8	Step Log	3.484inches ± 0.005	3.489 3.479		
9	Step Log	0.871inches ± 0.005	0.876 0.866		
10	Step Log	8.325inches ± 0.010	8.335 8.315		
11	Step Log	0.551inches ± 0.010	0.561 0.541		
12	Step Log	0.213inches + 0.005 - 0.000	0.218 0.213		
13	Step Log	0.128inches + 0.005 - 0.000	0.133 0.128		

Plex 12/9/19 9:57 AM Dart.Guerin.Kimberley



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044866



REVISED

Supplier: BIL003-VC
Billet Precision
2730 Fenton Road
Gloucester
ON
K1T 3T7 Canada
Phone: 6138221040

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044866
PO Date: 10/23/19
Due Date: 12/20/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items														
Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	202130	D3065-5P	D3065 REV.B			Step Leg - manufacture as per drawing D3065-5 Rev B ****IMPORTANT - verify grain direction as per drawing	Firmed	-	12/20/19	239 Ea	0 Ea	239 Ea	\$11.47/Ea	\$2,741.33
Line Item Note PRIORITY #4														
2	202194	D3065-7P	D3065 REV.B			Step Spacer - manufacture as per Dwg D3065-7 Rev B ***IMPORTANT - verify grain direction as per drawing	Firmed	-	12/20/19	119 Ea	0 Ea	119 Ea	\$7.50/Ea	\$892.50
Line Item Note PRIORITY #3														
3	202128	D3065-1P	D3065 REV.B			Step Spacer - manufacture as per dwg D3065-1 Rev B ***IMPORTANT - verify grain direction as per drawing	Firmed	-	12/20/19	119 Ea	0 Ea	119 Ea	\$6.00/Ea	\$714.00
Line Item Note PRIORITY #1														
4	202129	D3065-3P	D3065 REV.B			Step Spacer - manufacture as per dwg D3065-3 Rev B ***IMPORTANT - verify grain direction as per drawing	Firmed	-	12/20/19	119 Ea	0 Ea	119 Ea	\$8.00/Ea	\$952.00
Line Item Note PRIORITY #2														



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PURCHASE ORDER POHB044866



Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	203665	D3065-1P	D3065 REV.B			Step Spacer : Various STC's	Received	-	11/25/19	1 Ea	1 Ea	0 Ea	\$6.00/Ea	\$0.00
6	203662	D3065-5P	D3065 REV.B			Step Leg : Various STC's	Received	-	11/25/19	1 Ea	1 Ea	0 Ea	\$11.47/Ea	\$0.00
7	203663	D3065-7P	D3065 REV.B			Step Spacer : Various STC's	Received	-	11/25/19	1 Ea	1 Ea	0 Ea	\$7.50/Ea	\$0.00
8	203664	D3065-3P	D3065 REV.B			Step Spacer : Various STC's	Received	-	11/25/19	1 Ea	1 Ea	0 Ea	\$8.00/Ea	\$0.00
9	204367	D3065-5P	D3065 REV.B			Step Leg : Various STC's	Firmed	-	12/10/19	80 Ea	0 Ea	80 Ea	\$11.47/Ea	\$917.60
10	204369	D3065-7P	D3065 REV.B			Step Spacer : Various STC's	Firmed	-	12/10/19	40 Ea	0 Ea	40 Ea	\$7.50/Ea	\$300.00
11	204370	D3065-1P	D3065 REV.B			Step Spacer : Various STC's	Firmed	-	12/10/19	40 Ea	0 Ea	40 Ea	\$6.00/Ea	\$240.00
12	204371	D3065-3P	D3065 REV.B			Step Spacer : Various STC's	Firmed	-	12/10/19	40 Ea	0 Ea	40 Ea	\$8.00/Ea	\$320.00

Grand Total: \$7,077.43

Order Notes

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/9/19 10:08 AM Dart.Guerin.Kimberley

**BILLET PRECISION LTD.**

2730 Fenton Road
Gloucester, ON K1T 3T7
Phone: 613-822-1040
Fax:

RECEIVED

DEC 09 2019

Packing List**DART AEROSPACE LTD.**

Bill DART AEROSPACE LTD.
To: 1270 ABERDEEN STREET
Hawkesbury, ON K6A 1K7
Canada

Ship DART AEROSPACE LTD.
To: 1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Shipment No: 19349
Shipment Date: 12/06/19
Ship Via: Prepaid and Charge (Best Way)
Order Number: 18162
Order Date: 10/25/19

Customer Code: DART
Phone: (613) 632-5200
PQ Number: POHB044866
Terms: Net 30 Days

<u>Item</u>	<u>Quantity</u>					<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
	<u>Open</u>	<u>Shipped</u>	<u>Back Ord</u>	<u>Canceled</u>					
1	319	80	239		EA	D3065-5 STEP LEG ASSEMBLY			18162-01
2	159	40	119		EA	D3065-7 STEP LEG ASSEMBLY			18162-02
3	159	40	119		EA	D3065-1 STEP LEG ASSEMBLY			18162-03
4	159	40	119		EA	D3065-3 STEP LEG ASSEMBLY			18162-04

In keeping with our ISO 9001:2015 / AS9100 Rev D commitment, the product listed hereon has been manufactured from and in accordance with the specified requirements of the referenced purchase order. This is to certify that the above parts are RoHS compliant and have been processed in accordance with the terms of your purchase order and conform fully to the specifications quoted.

THE LIABILITY OF BILLET PRECISION LTD. WITH RESPECT TO THE SERVICES CHARGED FOR HEREIN SHALL IN NO EVENT EXCEED THE AMOUNT OF THE INVOICE. ALL CLAIMS OF SHORTAGE/ REJECTS MUST BE MADE WITHIN 10 DAYS FROM DELIVERY DATE.

UNAUTHORIZED RETURNS WILL NOT BE ACCEPTED AND RETURNED AT YOUR EXPENSE. AN RMA# MUST APPEAR ON ALL RETURNS ALONG WITH A COPY OF THE PAPERWORK.


Packing Clerk's Initials
BILLET PRECISION LTD.

Received In Good Order By
DART AEROSPACE LTD.

**BILLET PRECISION LTD.**

2730 Fenton Road
Gloucester, ON K1T 3T7
Phone: 613-822-1040
Fax:

Certificate of Conformance

To: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

From: BILLET PRECISION LTD.
2730 Fenton Road
Gloucester, ON K1T 3T7
Canada

Packing List No: 19349

Shipping Date: 12/06/19

Today's Date: 12/06/19

PO Number: POHB044866

Quantity Shipped	Unit	Description	Revision	Job Number	DAS 40 9-89
80	EA	D3065-5 STEP LEG ASSEMBLY		18162-01	
40	EA	D3065-7 STEP LEG ASSEMBLY		18162-02	
40	EA	D3065-1 STEP LEG ASSEMBLY		18162-03	
40	EA	D3065-3 STEP LEG ASSEMBLY		18162-04	

In keeping with our ISO 9001:2015 commitment, the product listed hereon has been manufactured from and in accordance with the specified requirements of the referenced purchase order. This is to certify that the above parts are RoHS compliant and have been processed in accordance with the terms of your purchase order and conform fully to the specifications quoted.

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RL
Inspector's Initials
BILLET PRECISION LTD.

12/6/2019
Authorized Signature
BILLET PRECISION LTD.

Entered: JK Date: SEP 02 2020



NCR No. 20-8436 WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>204367</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS					
Part No. <u>D3065-5</u>		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☒ Quality ☐		

Date: DEC 10 2019 Sequence #: 124 QTY Affected: 80 of 80 MRB (QSI042)

Description Work Order Deviation	Disposition	12.12.10 Completed By DAS 55 9-89 JUN 29 2020 Lead hand / Supervisor <u>[Signature]</u> 12/19/19 QC / QA Coordinator DAS 55 9-89 JUN 29 2020
0,128 holes are over tolerance 0,136 -Holes where found to be tapered therefore having one side to be over acceptable tolerance. From POHBO44866 received on dec 9, 2019	-Acceptable to use as is -Supplier to be contacted so he can resolve issue for future future orders.	

Root Cause Operator ☒ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY
☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function
☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	
☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
Other/Details:	